

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028445**Date Inspected:** 17-Sep-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Fritz Belford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

**OBG 12W**

This QA observed the following welders working in OBG 12W at various locations:

Authorized welder Jin Quan Huang #9340:

Welder Jin Quan Huang was observed continuing welding on weld 12W PP112 W2.1-BW1 (3G, CJP). The welder was observed utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1030 and preheating the weld to the over 150 degrees Fahrenheit prior to starting his weld. Welder Jin Quan Huang was also observed grinding and welding Visual Testing (VT) rejects on weld 12W W2.1-A1 using Welding Procedure Specification (WPS) ABF-WPS-D15-1001-Repair. The preheating temperatures and other welding parameters appeared to be in order as observed and in compliance with the noted Welding Procedure Specification's (WPS) above.

Authorized welder Guo Wu Chen #1556:

Welder Guo Wu Chen #1556 was observed grinding and welding Visual Testing (VT) rejects on weld 12W W2.1-A1 using Welding Procedure Specification (WPS) ABF-WPS-D15-1001-Repair. The preheating temperatures and other welding parameters appeared to be in order as observed and in compliance with the noted Welding Procedure Specification's (WPS) above.

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# WELDING INSPECTION REPORT

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## Magnetic Particle Testing

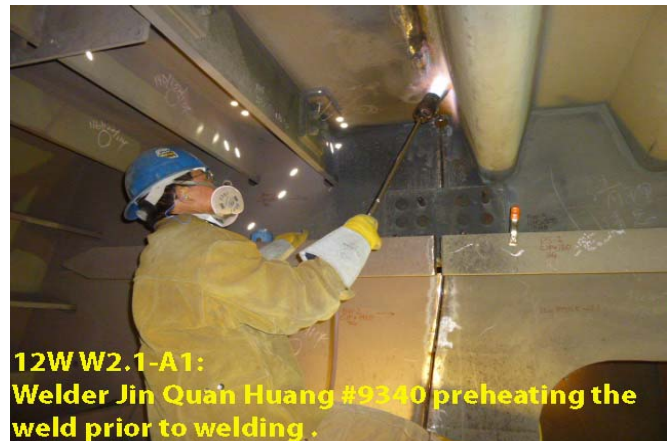
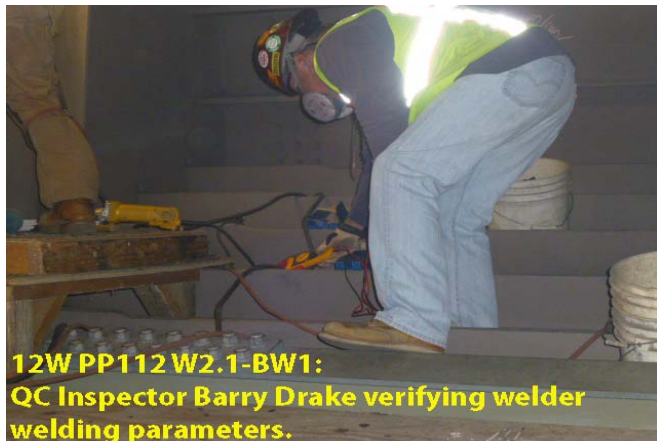
This QA performed Magnetic Particle Testing (MT) on the following weld:

12W W2.1-A1:

- Excavation at Y location 6005 (30 x 10 x 3mm Deep, MT Accept.)
- Excavation at Y location 6710 (22 x 10 x 5mm Deep, MT Accept.)

This QA randomly observed QC Inspectors Barry Drake checking the Welding Procedure Specification or WPS compliance of welders throughout the day. Also noted this day was QC Inspector Andrew Keech performing Ultrasonic Testing Shear Wave (UTSW) on the panel point web and flange splices at 12W PP115 W2.1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



## Summary of Conversations:

Conversations relevant to work performed on this date.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

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## WELDING INSPECTION REPORT

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remedial efforts please contact Gary Thomas - (916) 764 - 6027, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Belford,Fritz	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell,Bill	QA Reviewer

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